

Work Order ID 79522

79522

Page 1

January-26-12 4:10:18 PM

Item ID: D2803-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 26/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2803	Rev B								

100 0.00
100 Small Fab
 Small Fab Memo 0.00
 Small Fab Press D2805-2 and D2809 into arm as per Dwg D2803

12/01/30 (2)

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

5/2/1/30

(72)

120 0.00
120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
 Powdercoat Memo 0.00
 Powder Coating START TIME: 11:00 OVEN TEMPERATURE:
 FINISH TIME: 11:30

2X PM 12/01/31

WU480

3200F

11:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									

BL 12/31

150	Small Fab	0.00							
150									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D2803.								

ES 12/02/01 (2)

160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

S 12/02/01

(42)

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Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location ST49.	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

(2x) **SP 12-02-01.**

12/2/12

12-02-1
(2)

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-26-12 4:10:22 PM

Page 1

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Parent Item: D2803-042

D2803-042

Parent Item Name: Bracket Assembly

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-2 *D2803-2* Bracket		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST148				2					
				75223				2					
D2805-2 *D2805-2* Stop		Manufactured	No			100	Each	6.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
				76186				6					
NAS1515H3 *NAS1515H3* Washer		Purchased	No			100	Each	147.0000	4	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST277				147					
				116373				2					
				118078				6					
				118384				11					
				119438				28					
				120142				100					

Handwritten notes and signatures:
 ** 12/01/30
 2
 ** 12/01/30
 2
 ** 12/02/01
 8
 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January-26-12 4:10:22 PM

Page 2

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Parent Item: D2803-042

D2803-042

Parent Item Name: Bracket Assembly

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C16A

Purchased

No

150

Each

60.0000

2

4

AN3C16A

Bolt

**

EP 12/02/01

Location

Loc Qty

Loc Code

ST352

60

115835

1

118422

4

118628

13

119641

42

4

D2809

Manufactured

No

150

Each

29.0000

1

2

D2809

Bushing

**

EP 12/02/01

Location

Loc Qty

Loc Code

GA

7

72735

7

ST018

22

34035

12

77292

10

2

MS21043-3

Purchased

No

150

Each

1,170.000

2

4

MS21043-3

Nut

**

EP 12/02/01

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

565

119901

565

ST301

533

118077

2

118614

441

118686

30

119758

60

4

January-26-12 4:10:22 PM

Shop Packet Print

Page 2

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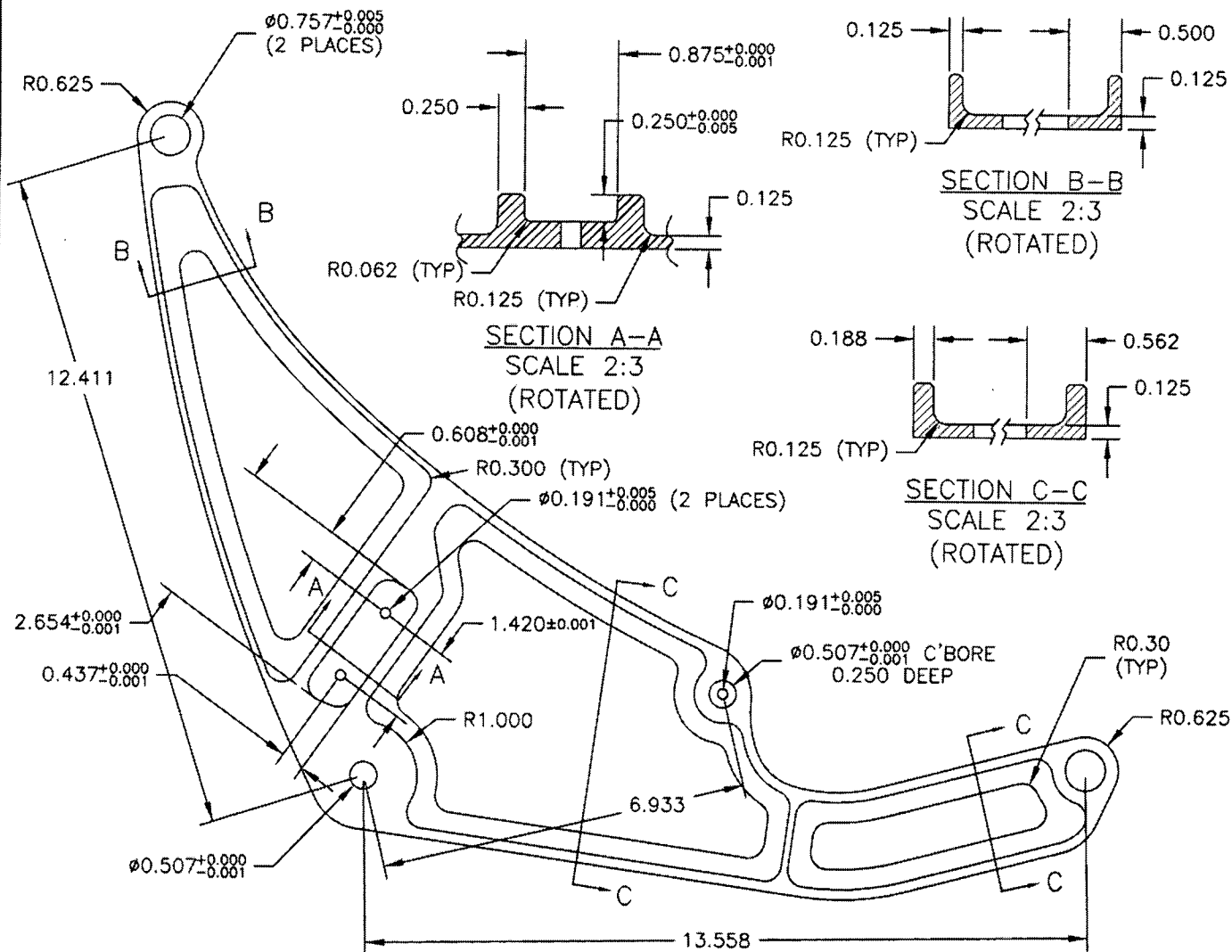
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03 11



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

STOP COPY
RETURN TO
ENGINEERING
FOR REVOLVED COPY
SUBJECT TO AMENDMENT
WORK ORDER

NO. 79522 A.L. J
12/01/24

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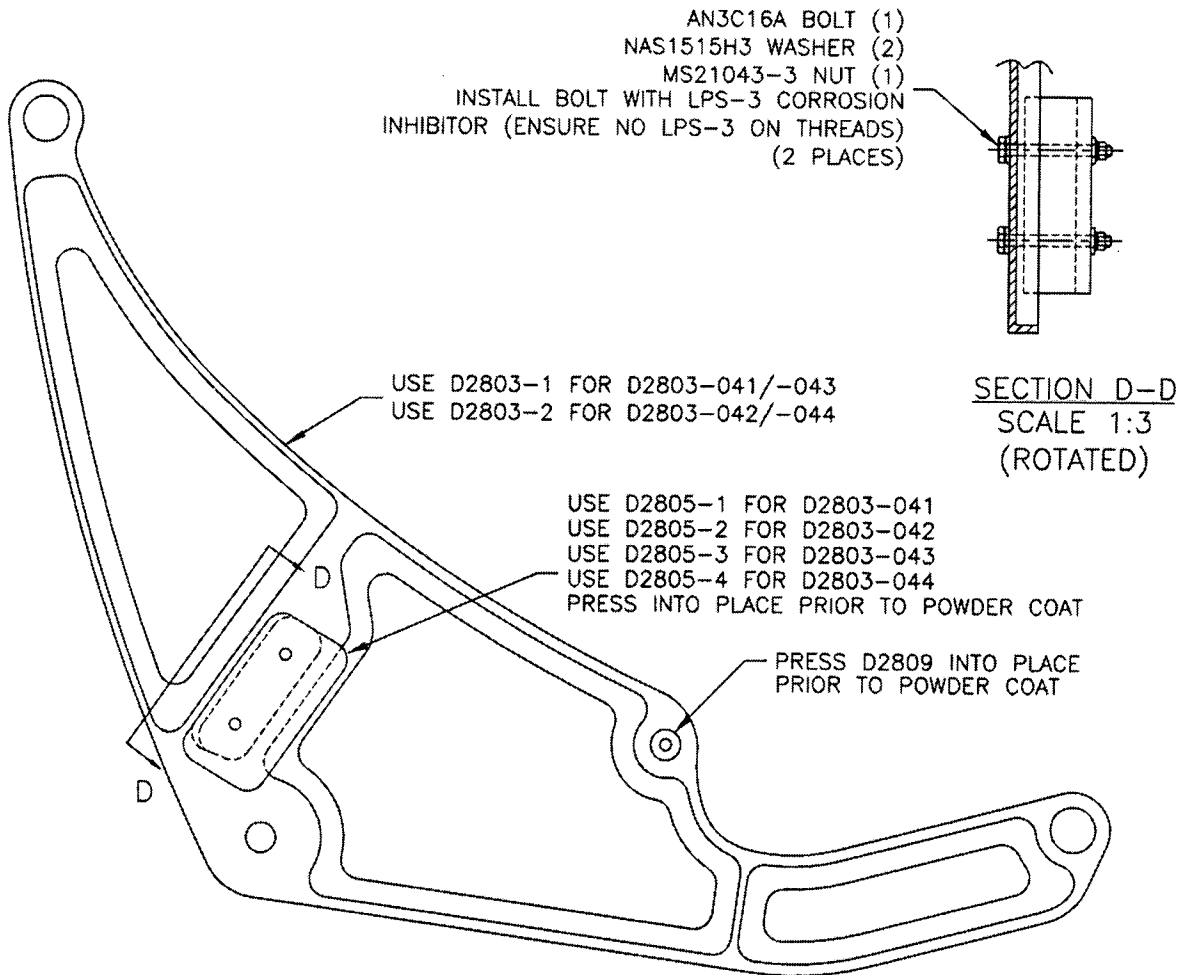
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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